

Date: Monday, 17/07/2006 2:57:26 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: JACK SADDLE	
Job Number	: 27897				
Estimate Number	: 11177				
P.O. Number	: N/A		Part Number	: D2281	
This Issue	: 17/07/2006 S.O. No. : N/A		Drawing Number	: D2281 REV G	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: G	
Previous Run	: 27897		Material	: N/A	
Written By			Due Date	: 24/07/2006	
Checked & Approved By			Qty:	100	Um: Each
Comment	Est Rev:A	Removed from 9 Digit	05-12-02	JLM	
	Est: rev B	06.07.17	waterjetEC		

## Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS .080
		
Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s) 304SS .080 batch: 4101873		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: G Prog Rev: G		
		
Comment: 2-Deburr if necessary <i>M 06 08 23</i> <i>SAD 06:08:23</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SAD 06:08:21</i>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <i>06:08:23</i> <i>100</i> <i>Counted</i>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: Deburr <i>M 06 08 23</i> <i>100</i>		

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 27897

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 06/08/28

100

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS22

CPL 06.08.31

06/09/01

9.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/01  
U 06/09/01

Job Completion



Date: Thursday, 7/13/2006 3:38:01 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: JACK SADDLE		
Job Number	: 27897		Part Number	: D2281		
Estimate Number	: 11177		Drawing Number	: D2281 REV G		
P.O. Number	:		Project Number	: N/A		
This Issue	: 7/13/2006	S.O. No. :	Drawing Revision	: G		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 8/10/2006	Qty:	100
Previous Run	: 26814		Um:	Each		
Written By	:					
Checked & Approved By	: <i>7/13/06.07.13</i>					
Comment	: Est Rev:A		Removed from 9 Digit	05-12-02	JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  <b>Comment:</b> PURCHASING Issue P/O: _____ Email or Ship Dxf file to vendor Laser cut as per Dwg D2281 Material release note required.
2.0	D2281F	Jack Saddle  <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Jack Saddle
3.0	PACKAGING 1	PACKAGING RESOURCE #1  <b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK  <b>Comment:</b> DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  <b>Comment:</b> Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/08/23	2	2 Parts were not in tolerance Because of the waterjet Program "the measurement were not Right" the height and Length of the part. <i>Jan</i>	PSPER 05/04/23	Scrap and destroy replace	SAD 06/08/23	<i>J</i> 06/08/23	<i>VS P&amp;Q 05/04/23</i>	<i>J</i> 06/08/23

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 NoDQA: *[Signature]*

Date: 06/04/01

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Thursday, 7/13/2006 3:38:01 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 27897

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

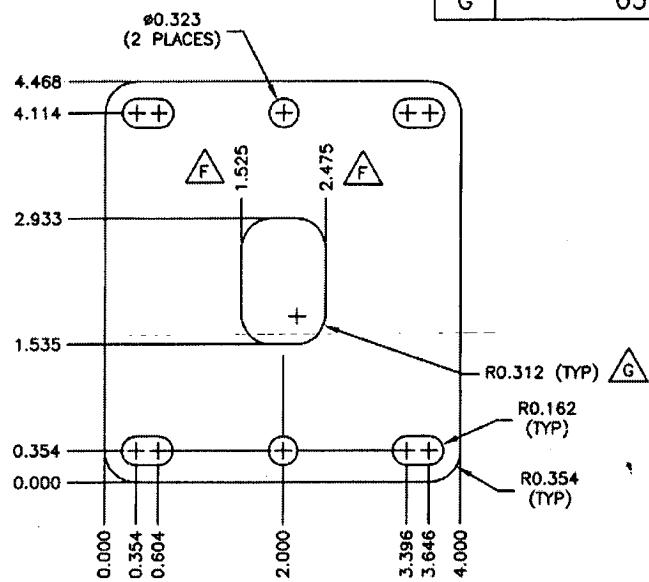
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

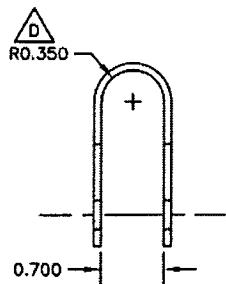
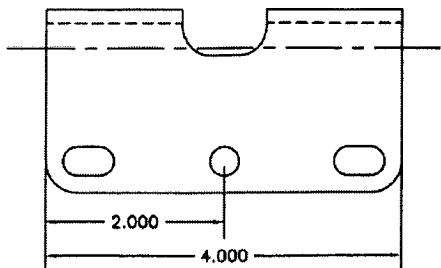


DESIGN BW	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>WMS</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

**RELEASED**  
*BS*  
05/08/11



FLAT LAYOUT



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *27891*

DART AEROSPACE LTD	Work Order:	27897
Description: JACK SANDIE	Part Number:	02281
Inspection Dwg:	Rev: G	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **X First Article      X Prototype**

Measured by: SAN	Audited by: ✓	Prototype Approval: N/A
Date: 26.08.21	Date: 06.08.23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	